

Ship March 9

Work Order ID 141155

141155

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January 29, 2016 8:57:49 AM

Item ID: D206-642-311BL Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Skidtube LH (Ael Blue)
Start Date: 1/21/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/9/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: SHA Date: 20160128 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	Q

100	Document Control	0.00	DAS	6					
100	DOCUMENT CONTROL		9-89						
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-311		CHG008						

MCS-16-03-01
MAR 09 2016
DAS 27 9-89

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

MAR 01 2016
DAS 6 9-89

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 09 2016
DAS 28 9-89
DAS 27 9-89

B141146

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 141155***141155***

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January 29, 2016 8:57:49 AM

Item ID: D206-642-311BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

IX 27 28 MAR 09 2016

MCS MAR 09 2016

MCS MAR 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 141155

141155

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
 IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M
 as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 14.04.25
 ECN14-520 DD verf:JLM IPP REV:O 15.10.09 ADDED
 BL DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341BL		Manufactured	No				Each	2.0000	1				
*D206-642-341RI *									**	B 141146			DAS 28 9-89
Replacement Skidtube (Fits LH or RH)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
				140301				1					
				140305				1					
D206-648-013BL		Manufactured	No				Each	0.0000	1				DAS 6 9-89
*D206-648-013RI *									**	142336			DAS 28 9-89
Ground Handling Wheel Modification													
D2932-1BL		Manufactured	No			110	Each	2.0000	1				DAS 6 9-89
*D2932-1RI *									**	141038			DAS 28 9-89
Saddle LH Out, 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST392				2					
				138656				2					
D2933-1BL		Manufactured	No			110	Each	1.0000	1				DAS 6 9-89
*D2933-1RI *									**	140961			DAS 28 9-89
Saddle LH In, 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST389				1					
				139883				1					

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Work Order ID: 141155

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141155

***D206-642-311RI ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2938-1BL

Manufactured No

110 Each

1.0000

1

1

***D2938-1RI ***

Saddle LH Out, 206

**

140964

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST390

1

139952

1

D2939-1BL

Manufactured No

110 Each

3.0000

1

1

***D2939-1RI ***

Saddle LH In, 206

**

140997

MAR 07 2016

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST391

3

138653

3

AN3-41A

Purchased No

110 Each

466.0000

8

8

AN3-41A

Bolt

**

DAS

6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

122416

20

over003

314

123355

314

ST347

132

123355

132

D2652

Manufactured No

110 Each

439.0000

16

16

D2652

Bushing

**

DAS

6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

394

136228

387

136792

7

MAR 01 2016

16

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Page 3

Work Order ID: 141155

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141155

***D206-642-311RI ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,544.000

8

8

MS21042L3

Nut

DAS

6

9-89

DAS

28

9-89

68-6
12
SVQ

Location

Loc Qty

Loc Code

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

186

m133790

186

NAS1149D0363J

Purchased

No

110

Each

1,858.000

8

8

NAS1149D0363J

Washer

DAS

6

MAR 01 1990

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

84

m130799

84

ST260a

1000

m134055

1000

ST263

774

m133790

274

m133932

500

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Work Order ID: 141155

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141155

***D206-642-311RI ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

322.0000

4

4

AN5-10A

Bolt

**

DAS

6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

over003

200

m133769

50

m134039

150

ST338

71

m133483

71

AN5-11A

Purchased

No

110

Each

109.0000

4

4

AN5-11A

BOLT

**

DAS

6
9-89

DAS
28
9-89

MAX U 7 4/10

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

50

M134039

50

ST338

59

M133077

9

M133234

50

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Work Order ID: 141155

141155

Parent Item: D206-642-311BL

***D206-642-311BI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,410.000

8

8

NAS1149D0563.I

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	53	
m125807	53	
ST260a	900	
m133769	400	
m133990	500	
ST263	354	
m133363	154	
m133938	200	
ST269	103	
m128257	103	

DAS
6
9-89

DAS
28
9-89

AN4-6A

Purchased

No

110

Each

1,185.000

12

12

AN4-6A

BOLT

DAS
27
9-89

Location

Loc Qty

Loc Code

CA	143	
M128403	43	
M130851	100	
over03	1000	
M133790	1000	
ST345	42	
M133316	18	
M133363	24	

DAS
6
9-89

DAS
28
9-89

MAR 01 2016

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Work Order ID: 141155

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH (Ael Blue)

141155

***D206-642-311RI ***

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

5,435.000

25

25

NAS1149D0463.J

WASHER

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST260a

2000

M134039

2000

ST263

1689

M134039

1689

ST269

1349

M130799

361

M132317

100

M132677

888

25

MS21042L4

Purchased

No

110

Each

3,356.000

12

12

MS21042L4

Locknut

DAS

6

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST007

1500

m134055

1500

ST303

1692

m133769

1692

ST305

97

m130922

97

12

DAS
28
9-89

MAR 01 2016

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Work Order ID: 141155

141155

Parent Item: D206-642-311BL

***D206-642-311BI ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110

Each

12.0000

1

D3407-043

Tow Ring

141923 Sep

BAS
27
9-89

Location

Loc Qty

Loc Code

st530

12

136685

10

136686

2

DAS
28
9-89

BLUE

D3456-1

Manufactured No

110

Each

125.0000

1

D3456-1

Washer

DAS
6
9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

118

136922

43

140756

75

DAS
28
9-89

D3457-1

Manufactured No

110

Each

66.0000

2

D3457-1

Washer

DAS
6
9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST037

8

127393

8

ST038

4

136442

4

ST038A

44

138904

44

DAS
28
9-89

MAR 01 2016

Picklist Print

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Work Order ID: 141155

141155

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH (Acl Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,034.000

1

MS21043-4

Nut

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

262

m132803

262

ST302

10

m133316

10

ST32

722

m133769

722

AN4C5A

Purchased

No

110

Each

80.0000

1

AN4C5A

Bolt

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

OVER002

50

m133990

50

ST345

30

m132857

10

m133135

20

NAS1149C0463R

Purchased

No

110

Each

212.0000

1

NAS1149C0463R

Washer

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

FP001

72

m127306

72

ST271

140

m128401

40

m133077

100

DAS

27

9-89

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Work Order ID: 141155

141155

Parent Item: D206-642-311BL

***D206-642-311BL ***

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

21.0000

D3413-1

O-Ring

**

1
B141SS2 SP

DAS
27
9-89

Location

Loc Qty

Loc Code

st530

21

136462

21

DAS
28
9-89

BLUE

D2712

Manufactured No

110 Each

433.0000

D2712

Set Screw

**

10

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

278

102226

12

135950

242

89929

10

93686

14

ST012a

100

140532

100

D2934

Manufactured No

110 Each

42.0000

D2934

Saddle Spacer

**

2

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

36

136116

36

DAS
27
9-89

MAR 01 2016

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Work Order ID: 141155

141155

Parent Item: D206-642-311BL

*D206-642-311BI *

Parent Item Name: Skidtube LH (Ael Blue)

Start Date: 1/21/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

30.0000

2

2

D2935

Saddle Spacer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

24

136244

24

DAS
6
9-89

DAS
27
9-89

MAR 01 2016

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1				X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6			1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7			1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8			1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9			1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOWRING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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